

Date: Wednesday, 3/14/2007 3:27:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 204 STEP LUG
Job Number	: 31209		
Estimate Number	: 11843		
P.O. Number	: N/A	Part Number	: D23381
This Issue	: 3/14/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2338 REV B
First Issue	: 3/14/2007	Type	: MACHINED PARTS
Previous Run	:	Project Number	: N/A
Written By	:	Drawing Revision	: B
Checked & Approved By	:	Material	: N/A
Comment	: Est. B00.03.24 Separated -1 from -2 EC		
Due Date : 3/23/2007 Qty: 6 Um: Each			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"	
			
Comment: Qty.: 0.3827 f(s)/Unit Total : 2.2964 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 0.5 x 6.0" Batch: <u>7103438</u> 1 blank makes one D2338-1 & one D2338-2			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut Blanks 8.75" long			
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2338 Tumble & Deburr			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
J.F. 07/03/20 ⑥			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Wednesday, 3/14/2007 3:27:38 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 STEP LUG

Job Number: 31209

Part Number: D23381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

03/13/22

(6)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

03/13/23

Job Completion



U 03/13/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



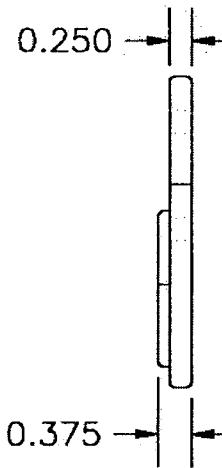
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B	K WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
13	13	D2338	SHEET 1 OF 1
DATE		TITLE	SCALE
95:01:25		ENDPLATE	1:12
B	96.03.29	RE-DESIGN AND ADD D2338-2	

RELEASED

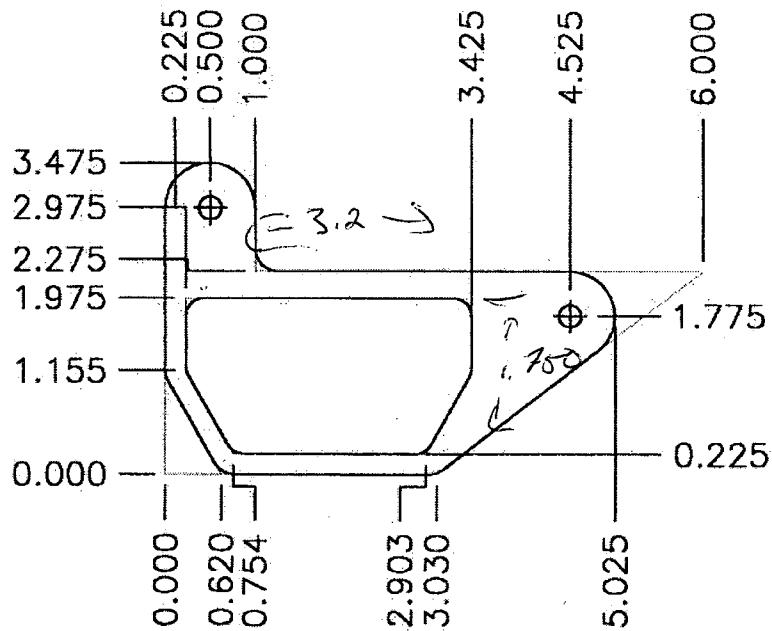
R
97/04/12

UNDER REVIEW

02-01-11

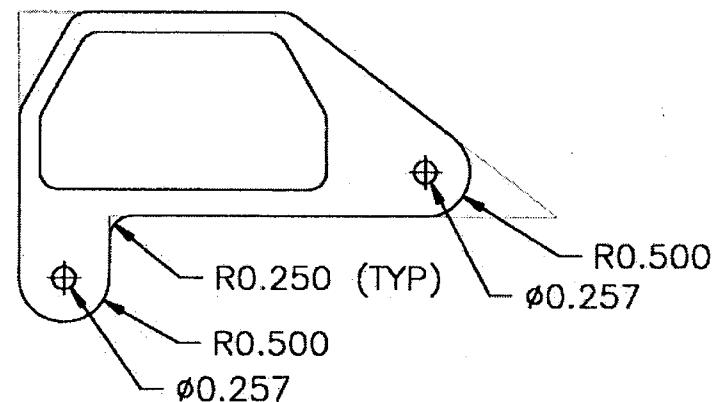


D2338-1



NOTE: BREAK ALL EDGES R0.063 MAX

D2338-2



MATERIAL: 6061-T6, 0.25 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 312 29

DART AEROSPACE LTD

Work Order:

31209

Description: D2338 End plate

Part Number: D2338-1

Inspection Dwg:

Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.975	± .010	1.980	/			
B .225	± .010	.225	/			
C 2.275	± .010	2.277	/			
D 3.475	± .010	3.478	/			
E .225	± .010	.226	/			
F .500	± .010	.500	/			
G 1.000	± .010	1.001	/			
H 3.425	± .010	3.421	/			
I 4.525	± .010	4.526	/			
J 5.025	± .010	5.029	/			
K						
L .250	± .010	.250	/			
M .375	± .010	.369	/			
N						
O Ø.257		Ø.257	/			
P R.500		R.508	/			
Q R.250		R.250	/			
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAAudited by: J.F.Prototype Approval: N/A

Date: 07/03/20

Date: 07/03/20

Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

